

Date: Thursday, 7/20/2006 1:09:42 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE KIT
Job Number	: 27998		
Estimate Number	: 10532		
P.O. Number	: N/A	Part Number	: K10003
This Issue	: 7/20/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: K10003 REV B
First Issue	: 7/20/2006	Project Number	: N/A
Previous Run	: 27920	Drawing Revision	: B
		Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 8/10/2006
Checked & Approved By	: <u>[Signature]</u> 06.07.21	Qty:	12 Um: Each
Comment	: Est: 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels for D205-634-011 and D204-635-011 per PPP K10003

CHG004

(12)

KS 06/10/10

2.0	D2570	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total: 288.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	B27586 x 3

About 78mcs

SRT 207

B28012 + 285 V

3.0	D2571	Saddle, Fwd, Out
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	B27761 x 8

B26511

4mcs

4.0	D2572	Saddle, Fwd, In
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	B27762

B27762

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2573 Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	B27889 x 6 ✓

B27889 x 6 ✓ B27058 x 6 ✓

6.0 D2574 Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	B27764 x 11 ✓

B27764 x 11 ✓ B27890 x 1 ✓

7.0 D27361 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	B26000 x 7

B26000 x 7 B27922 x 5

8.0 D27363 Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	B25837 ✓

B25837 ✓

9.0 D2747 Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B27631 ✓

B27631 ✓

6-07-07 2
→

D3533-1

Batch: B28032 ✓

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date: Thursday, 7/20/2006 1:09:42 PM
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Process Sheet

Customer: * CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 27998

Part Number: K10003

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	D2876	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	

B26367
B24851 X 14, D2876 X 10

11.0	D2877	Saddle Spacer
------	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)
Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	

B24897 X 3, 26513 X 21

12.0	D2968041	Tow Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	

B26210 ✓

13.0	AN46A	Bolt
------	-------	------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)
Bolt

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

AN46A M100478 ✓

14.0	AN446A	Bolt
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)
Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-46A	Bolt	

M100155 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:09:43 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 27998

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M18432 J

M101589 300 OK

Amount 114 SURT96
BAL 18

16.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN6-12A

Bolt

M101662 J

17.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 384.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

32

AN960JD416

Washer

M101369 J

18.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 96.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

8

AN960JD616

Washer

M100697 J

19.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

1

AN970-4

Washer

M100151 J

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/10/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: SADDLE KIT

Job Number: 27998

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 348.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

29

MS21042L4

Nut (or MS21042-4)

M19099 ✓

LB 06/08/08

21.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

Rec'd 7/22 (12)

22.0

PACKAGING 1

PACKAGING RESOURCE #4



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Rec'd 7/22 (7) Doc 10/10/05

23.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 10/10/05 (12)

Job Completion



U Dec 18 00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. K10003	REV. B SHEET 1 OF 1
DATE 00.11.22		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/ 212 /412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27998

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